

UNITED STATES DEPARTMENT OF AGRICULTURE
NATURAL RESOURCES CONSERVATION SERVICE

MATERIAL SPECIFICATION

MS-205: “CORRUGATED METAL PIPE and STRUCTURAL PLATE”

205.1 SCOPE

This specification governs the quality of zinc-coated iron or steel and aluminum alloy corrugated pipe and fittings.

205.2 PIPE

Corrugated metal pipe and fittings shall conform to the requirements of the applicable Specification for the specified classes and shapes of pipe, as listed:

Corrugated steel	AASHTO M-36 ASTM A-760
Corrugated aluminum	AASHTO M-196 ASTM B-745 ASTM B-746

The additional requirements apply for riveted seams:

- a. Unless otherwise specified, circumferential shop riveted seams shall have a maximum rivet spacing of 6 inches, except that 6 rivets will be sufficient for 12-inch diameter pipe.
- b. When close riveted pipe is specified: (1) the pipe shall be fabricated so that the rivet spacing in the circumferential seams shall not exceed 3 inches, except that 12 rivets will be longitudinal seams that will be covered by the coupling bands the rivets shall have finished flat heads or the rivets and holes shall be omitted and the seams shall be connected by welding to provide a minimum of obstruction to the seating of the coupling bands.
- c. Double riveting or double spot welding for corrugated steel pipe less than 42 inches in diameter, or corrugated aluminum pipe less than 30 inches in diameter may be required. When double riveting or double spot welding is specified, the riveting or welding shall be done in the manner specified for pipe 42 inches or greater in diameter.

205.3 COATINGS

Coatings shall conform to the requirements of ASTM A-849 or AASHTO M-190 for the specified material and type of coating.